

**TRANSMITTAL LETTER TO THE UNITED STATES
DESIGNATED/ELECTED OFFICE (DO/EO/US)
CONCERNING A FILING UNDER 35 U.S.C. 371**

R.35853

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR

10/019269

INTERNATIONAL APPLICATION NO.

PCT/DE 00/02056

INTERNATIONAL FILING DATE

23 June 2000

PRIORITY DATE CLAIMED

08 July 1999

TITLE OF INVENTION

**Method for Actuating A Wheel Brake Assembly, In Particular An Electromechanical Wheel Brake
Assembly Or A Mechanical System Involving Friction And Having Spring Elasticity**

APPLICANT(S) FOR DO/EO/US

SCHUMACHER, Axel

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☐ This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (24) indicated below.
4. ☒ The US has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c) (2))
 - a. ☒ is attached hereto (required only if not communicated by the International Bureau).
 - b. ☐ has been communicated by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☒ An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).
 - a. ☒ is attached hereto.
 - b. ☐ has been previously submitted under 35 U.S.C. 154(d)(4).
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3))
 - a. ☐ are attached hereto (required only if not communicated by the International Bureau).
 - b. ☐ have been communicated by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
10. ☒ An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).
11. ☒ A copy of the International Preliminary Examination Report (PCT/IPEA/409).
12. ☒ A copy of the International Search Report (PCT/ISA/210).

Items 13 to 20 below concern document(s) or information included:

13. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
14. ☒ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
15. ☒ A **FIRST** preliminary amendment.
16. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
17. ☐ A substitute specification.
18. ☐ A change of power of attorney and/or address letter.
19. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825.
20. ☐ A second copy of the published international application under 35 U.S.C. 154(d)(4).
21. ☐ A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).
22. ☐ Certificate of Mailing by Express Mail
23. ☒ Other items or information:

**Transmittal Sheets in duplicate w/fees charged to Dep.Acct. 07-2100; Copy of German Text Appl. w/2 sheets drawings;
Translation of German Text Appl. w/2 sheets drawings; Executed Declaration; Assignment to Robert Bosch GmbH;
Preliminary Amendment; Copy of PCT/RO/101, PCT/ISA/210/220, PCT/IPEA/401/409/416**

| | | | | | |
|--|--|---|--|--|--|
| U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 10/019269) | | INTERNATIONAL APPLICATION NO. PCT/DE 00/02056 | | ATTORNEY'S DOCKET NUMBER R.35853 | |
|--|--|---|--|--|--|

| | | | | | |
|---|--------------|--------------|-----------|--|----|
| 24. The following fees are submitted: BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)) : <input type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO \$1040.00 <input checked="" type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO \$890.00 <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$740.00 <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4) \$710.00 <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) \$100.00 ENTER APPROPRIATE BASIC FEE AMOUNT = | | | | CALCULATIONS PTO USE ONLY <div style="border: 1px solid black; height: 100px; width: 100%;"></div> | |
| Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (e)). | | | | \$890.00 \$0.00 | |
| CLAIMS | NUMBER FILED | NUMBER EXTRA | RATE | | |
| Total claims | - 20 = | 0 | x \$18.00 | \$0.00 | |
| Independent claims | - 3 = | 0 | x \$84.00 | \$0.00 | |
| Multiple Dependent Claims (check if applicable). <input type="checkbox"/> | | | | \$0.00 | |
| TOTAL OF ABOVE CALCULATIONS = | | | | \$890.00 | |
| <input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27. The fees indicated above are reduced by 1/2. | | | | \$0.00 | |
| SUBTOTAL = | | | | \$890.00 | |
| Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (f)). | | | | \$0.00 | |
| TOTAL NATIONAL FEE = | | | | \$890.00 | |
| Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable). <input type="checkbox"/> | | | | \$0.00 | |
| TOTAL FEES ENCLOSED = | | | | \$890.00 | |
| | | | | Amount to be: | \$ |
| | | | | refunded | |
| | | | | charged | \$ |

a. ☐ A check in the amount of _____ to cover the above fees is enclosed.

b. ☒ Please charge my Deposit Account No. **07-2100** in the amount of **\$890.00** to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. **07-2100**. A duplicate copy of this sheet is enclosed.

d. ☐ Fees are to be charged to a credit card. **WARNING:** Information on this form may become public. **Credit card information should not be included on this form.** Provide credit card information and authorization on PTO-2038.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

SEND ALL CORRESPONDENCE TO:

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Ronald E. Greigg
 SIGNATURE Reg. # 20093

Ronald E. Greigg
 NAME

31,517
 REGISTRATION NUMBER

28 December 2001
 DATE

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of

Axel SCHUMACHER

Based on PCT/DE 00/02056

For: Method For Actuating A Wheel Brake Assembly, In Particular An Electromechanical Wheel Brake Assembly Or A Mechanical System Involving Friction And Having Spring Elasticity

PRELIMINARY AMENDMENT

Commissioner for Patents
Washington, D.C. 20231

Sir:

Prior to examination, please amend the above-identified application as follows:

IN THE SPECIFICATION

Page 1, between the title and paragraph [0001] insert the following:

[0000.2] CROSS-REFERENCE TO RELATED APPLICATIONS

[0000.4] This application is a 35 USC 371 application of PCT/DE 00/02056 filed on June 23, 2000.

[0000.6] BACKGROUND OF THE INVENTION

delete paragraph [0001] and insert the following new paragraph:

[0001] Field of the Invention

between paragraph [0002] and [0003] insert the following:

[0002.5] Description of the Prior Art

Page 2, replace paragraphs [0006] and [0007] with the following amended paragraphs:

[0006] SUMMARY OF THE INVENTION

[0007] The method of the invention has the advantage that the braking force of the wheel brake assembly can be increased beyond the value that it has in the quasi-static terminal state, and the braking action is improved substantially.

Page 3, replace paragraph [0010] with the following amended paragraph:

[0010] The invention is based on the following concept: The wheel brake assembly is not absolutely rigid; even when embodied stiffly, it has some elasticity, against which the electric motor tightens the wheel brake assembly. The electric motor upon tightening must also overcome friction, for instance of the gear and the spindle drive, and because of the increasing forces, this friction load increases as the tightening increases. At a high tightening force, the friction load is high; that is, a not insignificant proportion of the torque of the electric motor is consumed to overcome the friction, and only the torque of the electric motor beyond that proportion increases the tightening force further. When the quasi-static terminal state is reached, the moving parts of the wheel brake assembly come to a stop, and the friction changes into static friction, which is higher. A further increase in the braking force would be possible then only if the torque of the electric motor could be increased so far that the static friction is overcome, and that the moving parts of the wheel brake assembly move again.

Page 5, replace paragraphs [0012] and [0013] with the following amended

release direction only so briefly that any stresses in the drive of the wheel brake assembly will be reversed and the static friction will change into a sliding friction.

[0013] The method of the invention can also be adopted for other mechanical systems involving friction and having spring elasticity and is not limited to wheel brake assemblies. The above explanations on the wheel brake assembly, in particular on the electromechanical wheel brake assembly, logically apply here as well and will not be repeated at this point.

Page 6, delete paragraph [0014] and replace paragraphs [0015] through [0017] with the following amended paragraphs:

[0015] For increasing the braking force incrementally, the method according to the invention is repeated multiple times. The method is repeated after a predetermined time after the onset of the re-tightening. This has the advantage that there is no need to determine or wait for whether the wheel brake assembly, after being re-tightened, has already come to a stop. The method is repeated if the wheel brake assembly/the system upon re-tightening has come to a stop or at least is virtually at a stop. In this way, each time the method is repeated a maximum increase in the braking force, or in the force exerted by the spring-elastic mechanical system that involves friction is attained.

[0016] Since the braking force, or the force exerted by the system, cannot be increased arbitrarily by the method of the invention but instead seeks to meet a limit value, the number of repetitions is limited.

[0017] According to one aspect of the invention, a distance that an actuating element of the wheel brake assembly covers in its actuation in the release direction is used as a standard for the actuation in the release direction. If the actuating element has traveled a fixed distance in the release direction, then the wheel brake assembly/the system is re-tightened. The travel of the actuating element in the release direction accordingly determines the brief period of time during which the wheel brake assembly/the system is actuated in the release direction. In this case, no time is measured. The actuating element can for instance be a rotor of the electric motor of the wheel brake assembly, which is rotated backward by a predetermined angle in order to actuate the wheel brake assembly in the release direction.

Page 7, replace paragraphs [0018] through [0022] with the following amended paragraphs:

[0018] BRIEF DESCRIPTION OF THE DRAWINGS

[0019] The invention will be described in further detail below in terms of an exemplary embodiment shown in the drawings, in which:

[0020] Fig. 1 is an overview of an electromechanical wheel brake assembly; and

[0021] Fig. 2 is a timing graph to illustrate the mode of operation of the method of the invention.

[0022] DESCRIPTION OF THE PREFERRED EMBODIMENT

Page 11, after paragraph [0031] insert the following new paragraph:

[0032] The foregoing relates to preferred exemplary embodiments of the invention, it being understood that other variants and embodiments thereof are possible within the spirit and scope of the invention, the latter being defined by the appended claims.

Page 12, line 1, delete "Claims" and insert --I Claim--.

IN THE CLAIMS

Please cancel claims 1-7 and add new claims 8-19.

8. A method for actuating a wheel brake assembly, in particular an electromechanical wheel brake assembly, comprising the steps of (a) initially actuating the brake assembly in the tightening direction to establish a quasi-static terminal braking state, then (b) actuating the wheel brake assembly (10) for a brief period of time in the release direction, and then (c) again actuating the brake assembly in the tightening direction, said brief period of time of the actuation in the release direction being selected to be so short that the braking force is reduced, if at all, only imperceptibly.

9. A method for actuating a mechanical system involving friction and having a spring elasticity to increase a force exerted by the system beyond a force attainable in a quasi-steady state, the method comprising the steps of (a) actuating the system for a brief period of time in the release direction and then (b) tightened again, the period of time of the actuation in the release direction being selected to be so short that the force exerted is reduced, if at all, only imperceptibly.

10. The method of claim 8 further comprising repeating steps (b) and (c).

11. The method of claim 9 further comprising repeating steps (b) and (c).

12. The method of claim 10, wherein steps (b) and (c) are repeated after a predetermined period of time after the onset of the re-tightening.

13. The method of claim 11, wherein steps (b) and (c) are repeated after a predetermined period of time after the onset of the re-tightening.

14. The method of claim 10, wherein steps (b) and (c) are repeated when the wheel brake assembly (10) comes to a stop upon re-tightening.

15. The method of claim 11, wherein steps (b) and (c) are repeated when the system (10) comes to a stop upon re-tightening.

16. The method of claim 10, wherein number of repetitions of steps (b) and (c) is limited.

17. The method of claim 11, wherein number of repetitions of steps (b) and (c) is limited.

18. The method of claim 8 wherein said brief period of time during which the wheel brake assembly (10) is actuated in the release direction is defined by a travel distance by which an actuating element of the wheel brake assembly (10) is moved in the release direction.

19. The method of claim 9 wherein said brief period of time during which the system (10) is actuated in the release direction is defined by a travel distance by which an actuating element of the system (10) is moved in the release direction.

IN THE ABSTRACT

Please substitute the attached abstract of the disclosure for the abstract as originally filed.


REMARKS

The above amendments are being made to place the application in better condition for examination.

Entry of the amendment is respectfully solicited.

Respectfully submitted,

Date: December 28, 2001


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REG/JLB/hhl

ABSTRACT OF THE DISCLOSURE

A method for actuating an electromechanical wheel brake assembly or a mechanical system involving friction and having spring elasticity wherein, to increase a braking force once a quasi-static terminal state of the wheel brake assembly is reached, the wheel brake assembly is actuated for a brief period of time in the release direction and then retightened. The period of time of the actuation in the release direction is selected to be so brief that the braking force is reduced, if at all, only imperceptibly.

VERSION WITH MARKINGS TO SHOW CHANGES MADE

Page 1, between the title and paragraph [0001]:

[0000.2] CROSS-REFERENCE TO RELATED APPLICATIONS

[0000.4] This application is a 35 USC 371 application of PCT/DE 00/02056 filed on June 23, 2000.

[0000.6] BACKGROUND OF THE INVENTION

delete paragraph [0001] and insert the following new paragraph:

[0001] [Prior Art] Field of the Invention

between paragraphs [0002] and [0003], insert the following:

[0002.5] Description of the Prior Art

Page 2, paragraphs [0006] and [0007]:

[0006] [Advantages of the Invention] SUMMARY OF THE INVENTION

[0007] The method of the invention [having the characteristics of claim 1] has the advantage that the braking force of the wheel brake assembly can be increased beyond the value that it has in the quasi-static terminal state, and the braking action is improved substantially.

Page 3, paragraph [0010]:

[0010] The invention is based on the following [thought] concept: The wheel brake assembly is not absolutely rigid; even when embodied stiffly, it has some elasticity, against which the electric motor tightens the wheel brake assembly. The electric motor

upon tightening must also overcome friction, for instance of the gear and the spindle drive, and because of the increasing forces, this friction load increases as the tightening increases. At a high tightening force, the friction load is high; that is, a not insignificant proportion of the torque of the electric motor is consumed to overcome the friction, and only the torque of the electric motor beyond that proportion increases the tightening force further. When the quasi-static terminal state is reached, the moving parts of the wheel brake assembly come to a stop, and the friction changes into static friction, which is higher. A further increase in the braking force would be possible then only if the torque of the electric motor could be increased so far that the static friction is overcome, and that the moving parts of the wheel brake assembly move again.

Page 5, paragraphs [0012] and [0013]:

[0012] For actuating the wheel brake assembly in the release direction, the electric motor need not necessarily be supplied with current in the release direction; often, it suffices to interrupt its current supply or reduce it, before the electric motor is again acted upon with maximum current supply in the tightening direction in order to re-tighten the wheel brake assembly. Nor is the wheel brake assembly actually released; instead, the actuation in the release direction is so brief that the braking force is reduced, if at all, only imperceptibly. It is not the goal of the invention to reduce the braking force of the wheel brake assembly temporarily and then increase it again; instead, by actuating the wheel brake assembly in the release direction, any stresses in bearings, gears, guides and the like, which can occur in the quasi-static terminal state because of the high tightening force of the wheel brake assembly, are meant to be reversed, and the static friction is to be overcome. An explanation for why the braking force of the wheel

brake assembly does not decrease despite a brief actuation in the release direction could be hysteresis resulting from the elasticity of the wheel brake assembly. In any case, in experiments, no loss of braking force during the brief actuation of the wheel brake assembly in the release direction was measurable. This can be due to the fact either that the braking force in fact did not decrease, or that the decrease in braking force was less than the measurement precision and hence was insignificant. A perceptible reduction in the braking force during the actuation of the wheel brake assembly in the release direction would be quite worrisome to a driver and would moreover lengthen the braking distance, which should be avoided and is unwanted according to the invention. What is meant by the expression [in claim 1] that the braking force is reduced if at all only imperceptibly is that the wheel brake assembly is actuated in the release direction only so briefly that any stresses in the drive of the wheel brake assembly will be reversed and the static friction will change into a sliding friction.

[0013] The method of the invention can also be adopted for other mechanical systems involving friction and having spring elasticity and is not limited to wheel brake assemblies. [This is the subject of coordinate claim 2.] The above explanations on the wheel brake assembly, in particular on the electromechanical wheel brake assembly, logically apply here as well and will not be repeated at this point.

Page 6, delete paragraph [0014] and paragraph [0015] through [0017]:

[0014] [Advantageous features and refinements of the method of the invention are the subject of the dependent claims.]

[0015] For increasing the braking force incrementally, the method according to the invention [as defined by claim 3] is repeated multiple times. [According to claim 4, the] The method is repeated after a predetermined [tb] time after the onset of the re-tightening. This has the advantage that there is no need to determine or wait for whether the wheel brake assembly, after being re-tightened, has already come to a stop. [According to claim 5, the] The method is repeated if the wheel brake assembly/the system upon re-tightening has come to a stop or at least is virtually at a stop. In this way, each time the method is repeated a maximum increase in the braking force, or in the force exerted by the spring-elastic mechanical system that involves friction is attained.

[0016] Since the braking force, or the force exerted by the system, cannot be increased arbitrarily by the method of the invention but instead seeks to meet a limit value, the number of repetitions is limited [in accordance with claim 6].

[0017] According to [claim 7] one aspect of the invention, a distance that an actuating element of the wheel brake assembly covers in its actuation in the release direction is used as a standard for the actuation in the release direction. If the actuating element has traveled a fixed distance in the release direction, then the wheel brake assembly/the system is re-tightened. The travel of the actuating element in the release direction accordingly determines the brief period of time during which the wheel brake assembly/the system is actuated in the release direction. In this case, no time is measured. The actuating element can for instance be a rotor of the electric motor of the wheel brake assembly, which is rotated backward by a predetermined angle in order

to actuate the wheel brake assembly in the release direction.

Page 7, paragraphs [0018] through [0022]:

[0018] [Drawing] BRIEF DESCRIPTION OF THE DRAWINGS

[0019] The invention will be described in further detail below in terms of an exemplary embodiment shown in the [drawing. Shown are] drawings, in which:

[0020] Fig. 1[,] is an overview of an electromechanical wheel brake assembly; and

[0021] Fig. 2[,] is a timing graph to illustrate the mode of operation of the method of the invention.

[0022] [Description of the Exemplary Embodiment] DESCRIPTION OF THE PREFERRED EMBODIMENT

Page 11, after paragraph [0031] insert the following new paragraph:

[0032] The foregoing relates to preferred exemplary embodiments of the invention, it being understood that other variants and embodiments thereof are possible within the spirit and scope of the invention, the latter being defined by the appended claims.

[Abstract] **ABSTRACT OF THE DISCLOSURE**

[The invention relates to a] A method for actuating [a wheel brake assembly, in particular] an electromechanical wheel brake assembly [(10)] or a mechanical system involving friction and having spring elasticity[. To] wherein, to increase a braking force once a quasi-static terminal state of the wheel brake assembly [(10)] is reached, the [invention proposes actuating the] wheel brake assembly [(10)] is actuated for a brief period of time in the release direction and then [to re-tighten it; the] retightened. The period of time of the actuation in the release direction is selected to be so brief that the braking force is reduced, if at all, only imperceptibly. [(Fig. 1)]

2/pts

METHOD FOR ACTUATING A WHEEL BRAKE ASSEMBLY, IN PARTICULAR AN
ELECTROMECHANICAL WHEEL BRAKE ASSEMBLY OR A MECHANICAL
SYSTEM INVOLVING FRICTION AND HAVING SPRING ELASTICITY

[0001] Prior Art

5 [0002] The invention relates to a method for actuating a wheel brake assembly, in particular an electromechanical wheel brake assembly or a mechanical system involving friction and having spring elasticity.

[0003] For the sake of clear illustration, the invention will be explained below concretely in terms of the actuation of an electromechanical wheel brake assembly. However, the invention is not intended to be limited to electromechanical wheel brake assemblies; for instance, the method of the invention is applicable to hydraulic or pneumatic wheel brake assemblies, especially if they are actuated by external force, and generally to mechanical systems involving friction and having spring elasticity.

15 [0004] Electromechanical wheel brake assemblies are known per se. For example, see German Patent Disclosure DE 42 29 042 A1. The known electromechanical wheel brake assemblies have an electric motor, whose rotary motion is transmitted by a gear to a rotation/translation conversion gear, typically a spindle drive, with which a friction brake lining can be pressed (tightening) against a brake body,
20 connected in a manner fixed against relative rotation to a vehicle wheel, such as a

brake disk or a brake drum, and lifted again (releasing). To convert the rotary motion of the electric motor into a translational motion for exerting pressure on the brake lining, a cam can for instance also be used. It is also known to embody a rotor of the electric motor as a nut of the spindle drive and to dispense with the gear between the electric motor and the spindle drive.

[0005] For braking, in the known electromechanical wheel brake assemblies the electric motor is supplied with current in the tightening direction, until a desired braking force is reached. The braking force can be increased until such time as a quasi-static terminal state is attained, at which a torque of the electric motor, at maximum current supply, no longer suffices to increase the contact pressure of the friction brake lining against the brake body any further.

[0006] Advantages of the Invention

[0007] The method of the invention having the characteristics of claim 1 has the advantage that the braking force of the wheel brake assembly can be increased beyond the value that it has in the quasi-static terminal state, and the braking action is improved substantially.

[0008] Another advantage of the method of the invention is that it requires no external measurement or input signals, such as the braking force exerted by the wheel brake assembly, in order to be performed. Sensors that measure the contact pressure of the friction brake lining at the brake body, or perform similar actions, can

therefore be omitted. The method of the invention can be employed in an existing and in particular electromechanical wheel brake assembly, without having to make such modifications as mounting a sensor on the wheel brake assembly.

[0009] In fading as well, that is, when the braking force of the wheel brake assembly fades as a consequence of overheating, the method of the invention can be employed to advantage to regain or even exceed the braking force that existed before the fading occurred.

[0010] The invention is based on the following thought: The wheel brake assembly is not absolutely rigid; even when embodied stiffly, it has some elasticity, against which the electric motor tightens the wheel brake assembly. The electric motor upon tightening must also overcome friction, for instance of the gear and the spindle drive, and because of the increasing forces, this friction increases as the tightening increases. At a high tightening force, the friction is high; that is, a not insignificant proportion of the torque of the electric motor is consumed to overcome the friction, and only the torque of the electric motor beyond that proportion increases the tightening force further. When the quasi-static terminal state is reached, the moving parts of the wheel brake assembly come to a stop, and the friction changes into static friction, which is higher. A further increase in the braking force would be possible then only if the torque of the electric motor could be increased so far that the static friction is overcome, and that the moving parts of the wheel brake assembly move again.

[0011] Since the torque of the electric motor cannot be increased arbitrarily, in the method of the invention a different course has been taken: To increase the braking force further once the quasi-static terminal state has been reached, the wheel brake assembly is actuated for a brief period of time in the release direction and then re-tightened. By the actuation in the release direction, and specifically with reinforcement from the elasticity of the wheel brake assembly rather than counter to the elasticity, the static friction is overcome, and the moving parts of the wheel brake assembly are put into motion again. After that, the wheel brake assembly is tightened again, and the braking force is greater than in the quasi-static terminal state, since the static friction need not be overcome; instead, the electric motor operates counter to the lesser sliding friction. The method can be repeated multiple times, in order to increase the braking force further in increments. In experiments, it was possible to increase the braking force by approximately one-third compared to the value in the quasi-static terminal state.

[0012] For actuating the wheel brake assembly in the release direction, the electric motor need not necessarily be supplied with current in the release direction; often, it suffices to interrupt its current supply or reduce it, before the electric motor is again acted upon with maximum current supply in the tightening direction in order to re-tighten the wheel brake assembly. Nor is the wheel brake assembly actually released; instead, the actuation in the release direction is so brief that the braking force is reduced, if at all, only imperceptibly. It is not the goal of the invention to reduce the braking force of the wheel brake assembly temporarily and then increase it again; instead, by actuating the wheel brake assembly in the release direction, any

stresses in bearings, gears, guides and the like, which can occur in the quasi-static terminal state because of the high tightening force of the wheel brake assembly, are meant to be reversed, and the static friction is to be overcome. An explanation for why the braking force of the wheel brake assembly does not decrease despite a brief actuation in the release direction could be hysteresis resulting from the elasticity of the wheel brake assembly. In any case, in experiments, no loss of braking force during the brief actuation of the wheel brake assembly in the release direction was measurable. This can be due to the fact either that the braking force in fact did not decrease, or that the decrease in braking force was less than the measurement precision and hence was insignificant. A perceptible reduction in the braking force during the actuation of the wheel brake assembly in the release direction would be quite worrisome to a driver and would moreover lengthen the braking distance, which should be avoided and is unwanted according to the invention. What is meant by the expression in claim 1 that the braking force is reduced if at all only imperceptibly is that the wheel brake assembly is actuated in the release direction only so briefly that any stresses in the drive of the wheel brake assembly will be reversed and the static friction will change into a sliding friction.

[0013] The method of the invention can also be adopted for other mechanical systems involving friction and having spring elasticity and is not limited to wheel brake assemblies. This is the subject of coordinate claim 2. The above explanations on the wheel brake assembly, in particular on the electromechanical wheel brake assembly, logically apply here as well and will not be repeated at this point.

[0014] Advantageous features and refinements of the method of the invention are the subject of the dependent claims.

[0015] For increasing the braking force incrementally, the method according to the invention as defined by claim 3 is repeated multiple times. According to claim 4, the method is repeated after a predetermined time after the onset of the re-tightening.

This has the advantage that there is no need to determine or wait for whether the wheel brake assembly, after being re-tightened, has already come to a stop.

According to claim 5, the method is repeated if the wheel brake assembly/the system upon re-tightening has come to a stop or at least is virtually at a stop. In this way, each time the method is repeated a maximum increase in the braking force, or in the force exerted by the spring-elastic mechanical system that involves friction is attained.

[0016] Since the braking force, or the force exerted by the system, cannot be increased arbitrarily by the method of the invention but instead seeks to meet a limit value, the number of repetitions is limited in accordance with claim 6.

[0017] According to claim 7, a distance that an actuating element of the wheel brake assembly covers in its actuation in the release direction is used as a standard for the actuation in the release direction. If the actuating element has traveled a fixed distance in the release direction, then the wheel brake assembly/the system is re-tightened. The travel of the actuating element in the release direction accordingly determines the brief period of time during which the wheel brake assembly/the

system is actuated in the release direction. In this case, no time is measured. The actuating element can for instance be a rotor of the electric motor of the wheel brake assembly, which is rotated backward by a predetermined angle in order to actuate the wheel brake assembly in the release direction.

5 [0018] Drawing

[0019] The invention will be described in further detail below in terms of an exemplary embodiment shown in the drawing. Shown are:

[0020] Fig. 1, an overview of an electromechanical wheel brake assembly; and

[0021] Fig. 2, a timing graph to illustrate the mode of operation of the method of the invention.

[0022] Description of the Exemplary Embodiment

[0023] Fig. 1 shows an overview of an electromechanical wheel brake assembly 10, known per se. Reference numeral 12 indicates an electronic control unit, which via an output line 14 controls an electric motor 16. The electric motor 16 is part of a brake actuator 18, which via a mechanical connection 20 actuates a brake device 22, with which a brake body 24, such as a brake disk, which is connected to a vehicle wheel, not shown, in a manner fixed against relative rotation can be braked. As its input signal, the control unit 12 receives a signal of a brake pedal sensor 26,

which measures a force by which a brake pedal is depressed, or a travel distance by which the brake pedal is depressed.

[0024] In an experimental setup, not shown, for performing the method of the invention, the wheel brake assembly 10 had a plate wheel gear, which was drivable with the electric motor 16 and whose plate wheel was mounted in a manner fixed against relative rotation on a nut of a spindle drive. The plate wheel gear and the spindle drive form the brake actuator 18. With a spindle of the spindle drive, a friction brake lining located in a brake caliper could be pressed against a brake disk 24 of the wheel brake assembly, embodied as a disk brake assembly. The spindle forms the mechanical connection 20, while the brake caliper forms the brake device 22. Because of the elasticity, especially of the brake caliper but also of the other components of the wheel brake assembly, that exist even in a rigid design, the mechanical connection 20 can be thought of as a spring element.

[0025] Upon the usual actuation of the wheel brake assembly 10, as a function of what the driver wants, the electric motor 16 is supplied with current in a tightening device until such time as a braking force dependent on what the driver wants is reached. The maximum attainable braking force occurs when the electric motor 16 is subjected to a maximum current supply. It tightens the wheel brake assembly 10 until its torque no longer suffices to increase the tightening force further. This is the so-called quasi-static terminal state.

[0026] If the braking force is to be increased further, then according to the invention the wheel brake assembly 10 is actuated for a brief period of time in the release direction; for this purpose, it can suffice to interrupt the current supply to the electric motor 16 briefly, and there is no absolute necessity of supplying current to the electric motor 16 in the release direction. Next, the electric motor 16 is again supplied with maximum current in the tightening direction. By the brief actuation of the wheel brake assembly 10 in the release direction, any stresses existing in the brake actuator 18 because of the high tightening force have gone away, and a static friction, which ensues because of the stoppage of the wheel brake assembly 10 once the quasi-static terminal state has been reached, has been overcome, specifically by utilizing the elasticity of the wheel brake assembly 10. In the ensuing re-tightening, an increased braking force is thereby attained, which is beyond that of the quasi-static terminal state. The period of time for actuating the wheel brake assembly 10 in the release direction is selected to be so brief that the braking force is either not reduced, or at most is reduced imperceptibly.

[0027] For increasing the braking force further in increments, the method of the invention is repeated. The repetition can be done when the electric motor 16 and the brake actuator 18, upon re-tightening, are completely at a stop or nearly at a stop. The repetition of the method can also be done after a fixedly defined period of time, which can end even before the stoppage of the electric motor 16 and the brake actuator 18 upon re-tightening.

[0028] Even if the braking force of the wheel brake assembly 10 fades, for instance because of overheating (fading) during braking, by application of the method of the invention the braking force can be restored to its original value or even increased beyond it. The use of the method of the invention is not limited to electromechanical wheel brake assemblies; in particular, it can also be used for electrohydraulic or electropneumatic brake systems. The method of the invention is furthermore not limited to wheel brake assemblies; it can also be adopted in other mechanical systems involving friction and having spring elasticity.

[0029] A preferred realization of the method of the invention is for it to be implemented as a program in a microcomputer of the control unit 12.

[0030] The course of the method of the invention can be seen from the timing graph in Fig. 2. Here the course of the contact pressure F of a friction brake lining against the brake disk 24 is represented by a dot-dashed line, and a rotational angle w of a rotor of the electric motor 16 is plotted with a dashed line, both over the time t . The electromechanical wheel brake assembly 10 used in the experimentation has been described above at the beginning of the description of the exemplary embodiment. F_0 indicates the contact pressure of the friction brake lining against the brake disk at maximum current supplied to the electric motor 16, that is, in the quasi-static terminal state of the wheel brake assembly 10. To increase the contact pressure F further, in the experiment described the rotor of the electric motor 16 is rotated backward at time T_1 by an angle of approximately 15° in the release direction, and then the electric motor 16 was supplied with current again in the tightening direction.

As shown in Fig. 2, upon re- tightening, the rotor of the electric motor 16 rotates past its position in the quasi-static terminal state; the contact pressure F also increases in stages to a value F_1 , which is greater than the contact pressure F_0 in the quasi-static terminal state. At time T_2 , the rotor of the electric motor 16 has been rotated in reverse by 15° again, and then the electric motor has been subjected to maximum current supply once again, as a result of which the rotor has rotated onward again and the contact pressure F has been increased further to the value F_2 . By repetition of the method, the contact pressure F can be increased by approximately one-third, compared to the contact pressure F_0 in the quasi-static terminal state of the wheel brake assembly 10. The period of time of the reverse rotation of the rotor by 15° and of the ensuing forward rotation past the original position was approximately 15 ms, and the chronological spacing between two repetitions was approximately 0.15 to 0.2 seconds.

[0031] The period of time during which the wheel brake assembly 10 is actuated in the release direction was determined in the experiment described by the angle by which the rotor of the electric motor 18 was rotated in reverse.

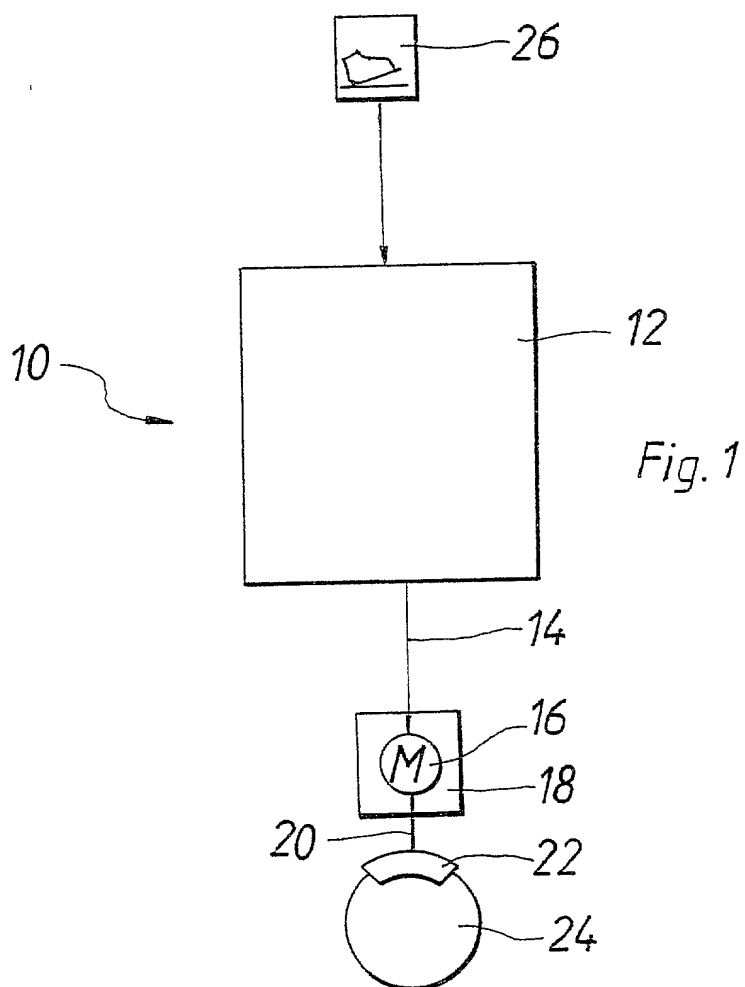
Claims

1. A method for actuating a wheel brake assembly, in particular an electromechanical wheel brake assembly, characterized in that to increase a braking force after a quasi-static terminal state has been reached, the wheel brake assembly (10) is actuated for a brief period of time in the release direction and then tightened again, and that the period of time of the actuation in the release direction is selected to be so short that the braking force is reduced, if at all, only imperceptibly.
2. A method for actuating a mechanical system involving friction and having a spring elasticity, characterized in that to increase a force exerted by the system beyond a force attainable in a quasi-steady state, the system is actuated for a brief period of time in the release direction and then tightened again, and that the period of time of the actuation in the release direction is selected to be so short that the force exerted is reduced, if at all, only imperceptibly.
3. The method of claim 1 or 2, characterized in that the method is repeated.
4. The method of claim 3, characterized in that the method is repeated after a predetermined period of time after the onset of the re-tightening.
5. The method of claim 3, characterized in that the method is repeated when the wheel brake assembly (10)/the system comes to a stop upon re-tightening.

6. The method of claim 3, characterized in that the number of repetitions is limited.

7. The method of claim 1 or 2, characterized in that the brief period of time during which the wheel brake assembly (10)/the system is actuated in the release direction is defined by a travel distance by which an actuating element of the wheel brake assembly (10)/the system is moved in the release direction.

1/2



2/2

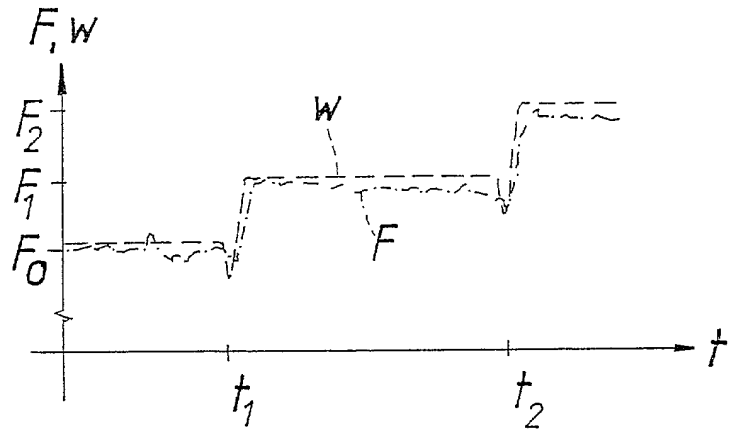


Fig. 2

Docket No.
R.35853

Declaration and Power of Attorney For Patent Application

English Language Declaration

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

APPARATUS FOR DELIVERING AN ELONGATED INDIVIDUAL PIECE, SEVERED FROM AN EXTRUDED COLUMN, TO A PROCESSING SYSTEM

the specification of which

(check one)

☐ is attached hereto.

☒ was filed on 23 JUNE 2000 as United States Application No. or PCT International Application Number PCT/DE 00/02056

and was amended on _____

(if applicable)

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119(a)-(d) or Section 365(b) of any foreign application(s) for patent or inventor's certificate, or Section 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate or PCT International application having a filing date before that of the application on which priority is claimed.

| Prior Foreign Application(s) | | | Priority | Claimed |
|------------------------------|-----------------------------|-----------------------------|-------------------------------------|---------|
| <u>1 99 31 821.2</u> | <u>GERMANY</u> | <u>08 JULY 1999</u> | <input checked="" type="checkbox"/> | |
| (Number) | (Country) | (Day/Month/Year Filed) | | |
| <u> </u> | <u> </u> | <u> </u> | <input type="checkbox"/> | |
| (Number) | (Country) | (Day/Month/Year Filed) | | |
| <u> </u> | <u> </u> | <u> </u> | <input type="checkbox"/> | |
| (Number) | (Country) | (Day/Month/Year Filed) | | |

I hereby claim the benefit under 35 U.S.C. Section 119(e) of any United States provisional application(s) listed below:

(Application Serial No.)

(Filing Date)

(Application Serial No.)

(Filing Date)

(Application Serial No.)

(Filing Date)

I hereby claim the benefit under 35 U. S. C. Section 120 of any United States application(s), or Section 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. Section 112, I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, C. F. R., Section 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application:

(Application Serial No.)

(Filing Date)

(Status)
(patented, pending, abandoned)

(Application Serial No.)

(Filing Date)

(Status)
(patented, pending, abandoned)

(Application Serial No.)

(Filing Date)

(Status)
(patented, pending, abandoned)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (list name and registration number)

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